



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4883-5

Job Sheet 183454



Part No: D4883-5

Job Qty: 5 ea

Part Name: End Fitting



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/18/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 3 IPP REV A RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Machining-3		
100	Doosan	5 pcs	10/12/18	10/12/18	0.00	2.14	Doosan		
110	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Machining-3		
120	CNC Vertical Machining	5 pcs	10/12/18	10/12/18	0.29	4.63	HAAS1-5		
130	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC2 Machining-3		
140	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC8 Machining-3		
150	Outsource	5 pcs	10/12/18	10/12/18	0.00	0.00	Outsource2		
160	Packaging	5 pcs	10/12/18	10/12/18	0.00	0.00	Packaging2		
190	QC	5 pcs	10/12/18	10/12/18	0.00	0.00	QC5		
200	Packaging	5 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-2		
210	QC21-SA	5 Ea	10/12/18	10/12/18	0.00	0.00	QC21		

Part Op 100 - 1- Turn as per Dwg. D4883-5 Turning Detail & Folio FB254. 2- USE DT10005 For sizing blanks.
Descriptions: 120 - 1-Machine as per Folio Fb254 & Dwg D4883-5 END FITTING. deburr and Break all sharp edges.

150 - ssue P/O: D1545

160 - Certificate of conformity is req'd.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H900-R2.000	17-4 SS H900 Round Bar 2.000"	1.1800 ft (.236 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H900-R2.000	1	9	0

Part Specifications

Specifications could not be found.

Plex 9/18/18 11:29 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

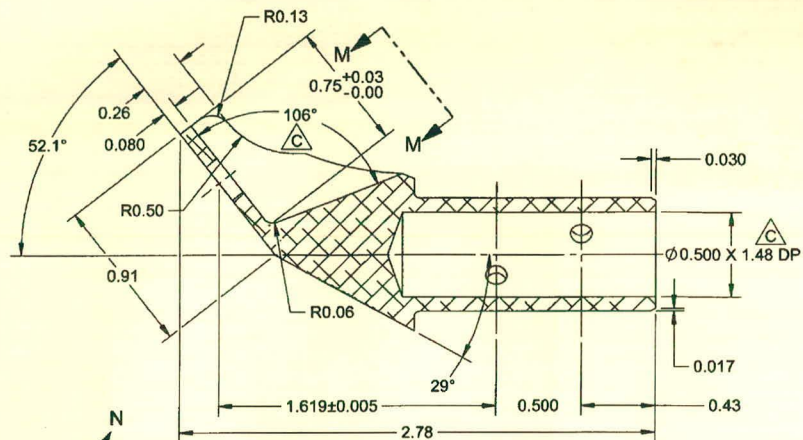


WORK ORDER NON-CONFORMANCE / UPDATE

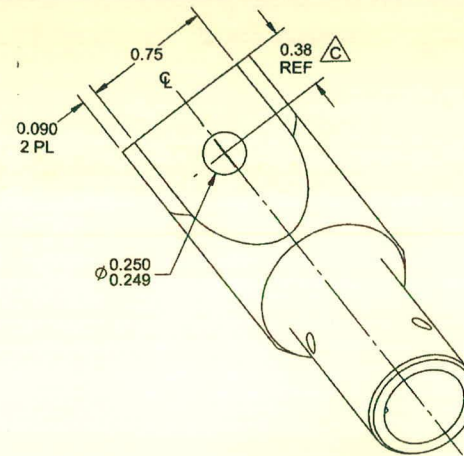
QA Closed: _____ Date: _____

Work Order update only ☐

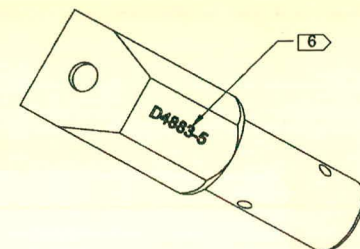
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								



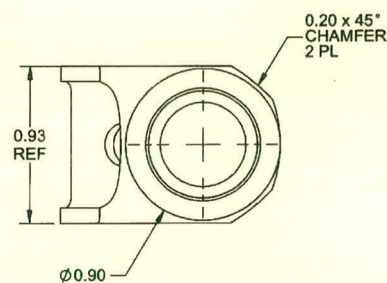
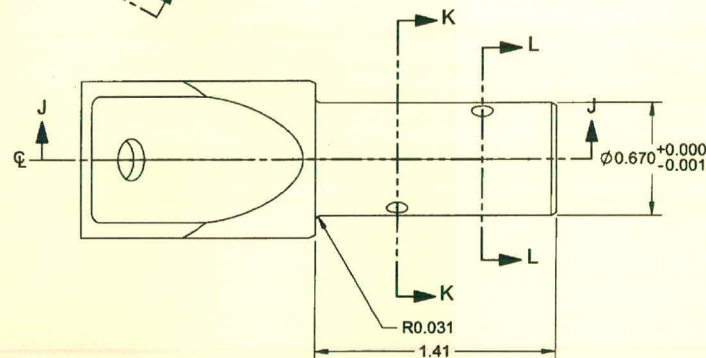
SECTION J-J



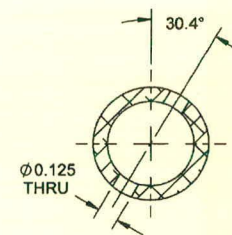
AUXILIARY VIEW M-M



AUXILIARY VIEW N-N



SECTION K-K



SECTION L-L

D4883-5 END FITTING

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.
ENGRAVE P/N USING 0.10 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) WEIGHT: 0.20 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D4883-5-REVC.SLDPR" "

RELEASED
2015 JAN 27

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO. D4883	REV. C
MFG. APPR.	RQ		SHEET 3 OF 4
APPROVED	HS	TITLE END FITTING	SCALE NTS
DE APPR.	DS	DATE 15.01.13	

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DARI
AEROSPACE

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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S120688



Part: D4883-5

Job No: 183454

Serial No/Batch: S120688

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/23/18



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041545**

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO041545
PO Date: 11/1/18
Due Date: 11/9/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	OH182881	SWA25A-3-OH	Electric Swivel 25,000 lb Safe Work Load (11,340 Kg) NDT -Issue P/O to Skyservice: P/O Magnaflux parts as per dwg C of C is required	Firmed	-	11/9/18	1 pcs	0 pcs	1 pcs	\$27.8125/pcs	\$27.81
2	183763	D4885-1	End Fitting : Various STC's Issue P/O: LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required	Firmed	-	11/9/18	6 pcs	0 pcs	6 pcs	\$27.8125/pcs	\$166.88
3	184456	D4883-3	End Fitting : Various STC's Issue P/O: Certificate of conformaty is required.	Firmed	-	11/9/18	4 pcs	0 pcs	4 pcs	\$27.8125/pcs	\$111.25
4	183454	D4883-5	End Fitting : Various STC's Issue P/O:	Firmed	-	11/9/18	5 pcs	0 pcs	5 pcs	\$27.8125/pcs	\$139.06
Grand Total:										\$445.00	

DAS
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PURCHASE ORDER PO041545

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/7/18 2:17 PM dart.tsimiklis.chrisoula

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO38045	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO041545
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON :

- 1 ELECTRIC SWIVEL (6 PCS), P/N# SWA25A-3 OH, J/S# OH182881,
- 6 END FITTINGS, P/N# D4885-1, J/S# 183763
- 4 END FITTINGS, P/N# D4883-3, J/S# 184456
- 5 END FITTINGS, P/N# D4883-5, J/S# 183454

Action Taken:						Date:	Initial/Stamp:
LPI & MPI C/O IAW ASTM E-1417 AND E-1444 REV. 16							
NO CRACK FOUND							
MAGBENCH S/N 208123 CAL DUE: 5-APR-2019 POWDER 14A BATCH# MPO13600 CARRIER II BATCH# MPO20165 PEN ZL-37, MPO13139, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO15030, UV LIGHT M-20142						NOV 05 2018	
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

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I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
		NOV 05 2018
Name: RAFIK MELIKIAN		

